

Date: Wednesday, 4/4/2007 9:03:35 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 31609A		
Estimate Number	: 10839		
P.O. Number	: <u>N/A</u>	Part Number	: D22491
This Issue	: 4/4/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D2249 REV. E
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 31502	Drawing Revision	: E
	Type : SMALL /MED FAB	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 4/11/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	10 Um: Each
Comment	: Est: D 05/02/04 Added Step 9 KJ/RF Est Rev:E Now on Waterjet 07-03-08 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0903 sf(s)/Unit Total : 0.9030 sf(s)

304/316 .063 Sheet

Batch: M103961

SAD 07/04/14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: EProg Rev: E

[Signature] 07/04/14  
 SAD 07/04/14

(10)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/04/14

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

PD 07-06-28 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:35 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31609A

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2007/06/29

Job Completion



u 07-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

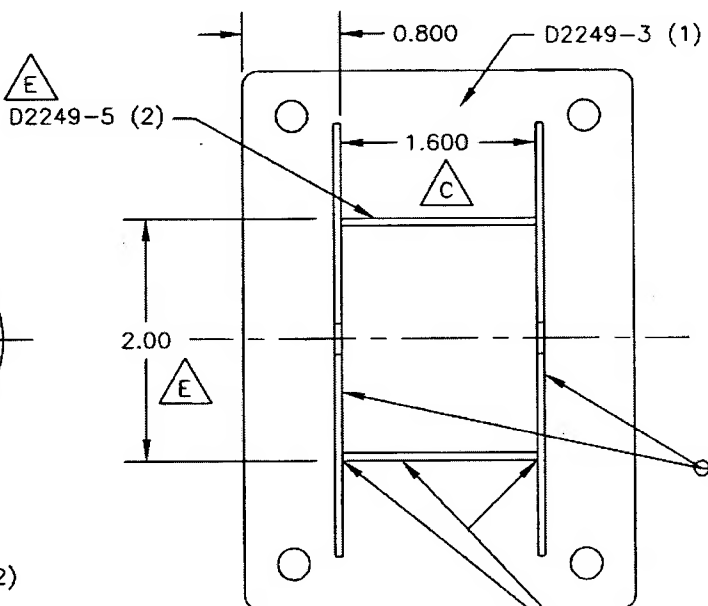
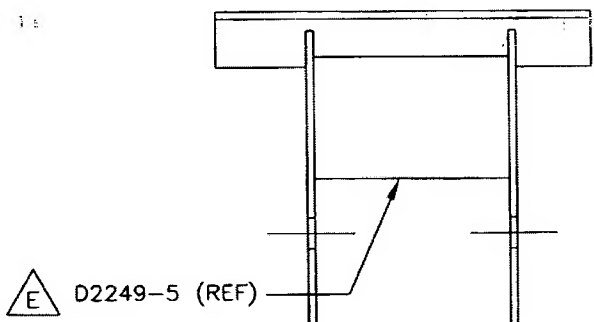
NOTE: Date & initial all entries



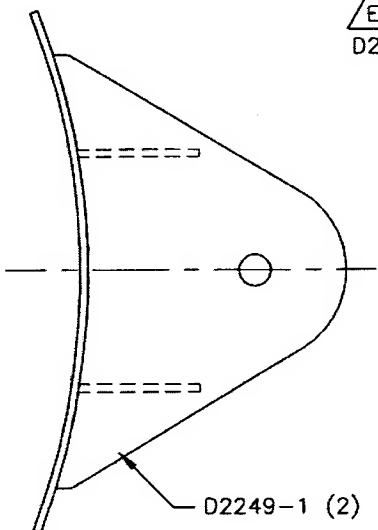


**DART****RELEASED**  
99.10.12 KGE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
AE	RF	DRAWING NO.	D2249	REV. E
CHECKED KE	APPROVED #	TITLE	D2249	SHEET 1 OF 4
DATE 99.09.20		FITTING		SCALE NTS
A	94.06.20	NEW ISSUE		
B	95.11.30	DIMENSION CHANGE		
C	95.12.14	DIMENSION CHANGE		
D	98.04.30	Ø0.261 WAS Ø0.257 (ISR A179) REMOVED DUPLICATE DIMENSIONS		
E	99.09.20	ADDED GUSSET		

**D2249-041 ASSEMBLY**

MATERIAL: AISI 304/316 SS, 0.063 THICK  
WELD PER DART QSI 004  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



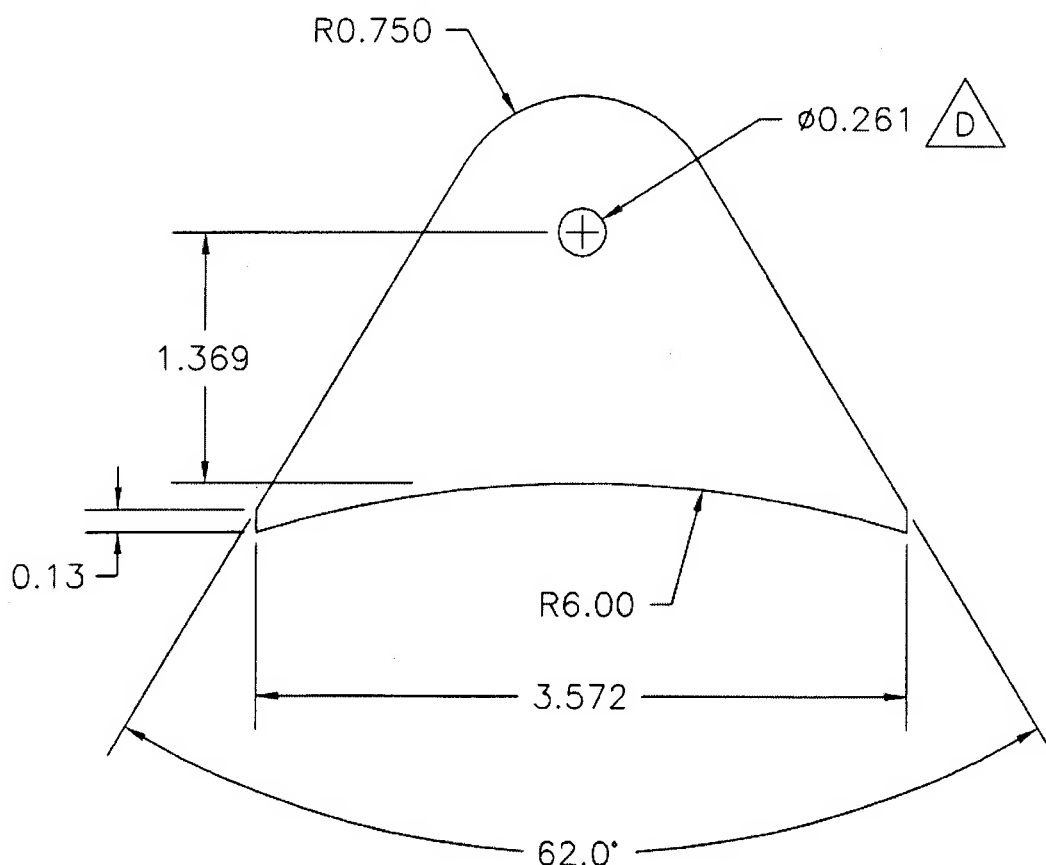
SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 316094



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED  
99.10.12 *KE*



D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

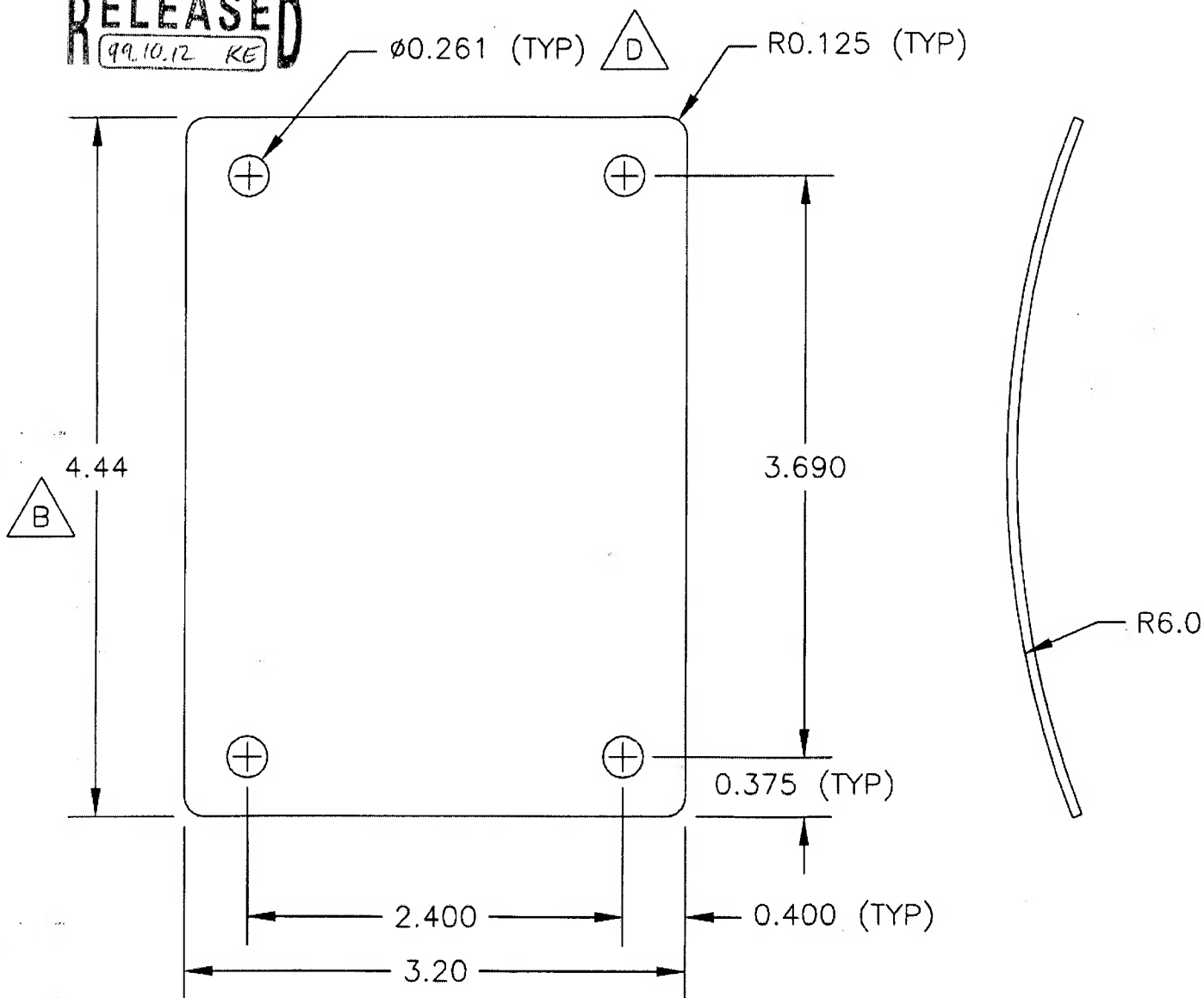
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WORK ORDER  
NO. 31609A





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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

**RELEASED**  
99.10.12 KE



FLAT PATTERN

D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

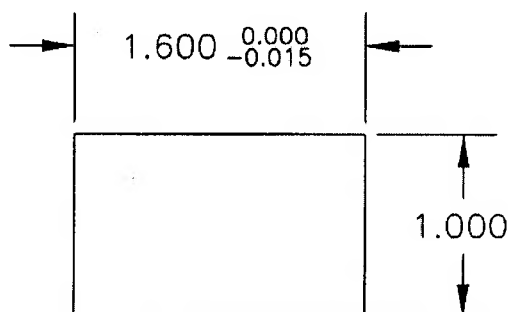
BEND DETAIL

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WORK ORDER  
NO. *31609A*



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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
49.10.12 *KE*



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE

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WORK ORDER  
NO. *31609A*